



TROUBLESHOOTING GUIDE FOR PAD PRINTING

PROBLEM**COLOUR DOES NOT MATCH REPRO COPY**

- | | | | | |
|--|----------------------------|------------------|---|---|
| > too thin | > depth is varying | > wrong form | > changing substrate colours | > repro copy was applied by double or single printing |
| > colour too transparent | > cliché material is wrong | > rough surfaces | > repro copy was formulated on another substrate colour | |
| > wrong formulation (if special shade) | > screening width is wrong | | | |
| > changed substrate colour | | | | |

POSSIBLE SOLUTIONS

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|--|---------------------------------------|--------------------|--|--------------------------------|
| ● adjust colour | ● measure depth | ● use correct form | ● formulate colour shade on surface substrate colour | ● check double/single printing |
| ● mix more opaque colour | ● use correct type of cliché material | ● insert new pad | ● preprint white | |
| ● formulate colour on correct substrate colour | ● use correct screening width | | | |

PROBLEM**INK SPLASHES ON SUBSTRATE**

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|------------------------|------------|-----------------|----------------------------|--------------------------|
| > too thick | > too deep | > too flat | > static charge on surface | > low humidity |
| > ink builds up on pad | | > rough surface | | > process speed too high |

POSSIBLE SOLUTION

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|------------------------------|----------------------|-------------------|------------------|----------------------------|
| ● re-thin | ● measure depth | ● use sharper pad | ● ionize surface | ● check humidity (60-80%) |
| ● mix ink with other thinner | ● use flatter cliché | ● use new pad | | ● slow down printing speed |

PROBLEM**DISTORTION IN THE PRINTED IMAGE**

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|---|--------------------------------|-------------------------------|
| > wrong form | > too soft | > unsuitable substrate holder |
| > wrong hardness | > not distortion-free | > no horizontal position |
| > pressure too high | > deep spots | |
| > pressure on cliché and substrate not the same | > edges due to pad deformation | |
| > wrong touch-down of pad | | |

POSSIBLE SOLUTION

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|---|-------------------|--|
| ● use correct form | ● other materials | ● stable, firm substrate holder |
| ● use correct hardness | ● pad assembly | ● substrate must be in a horizontal position to the cliché |
| ● use less pressure | ● special pad | |
| ● use same pressure on cliché and substrate | | |
| ● use other touch-down point | | |

PROBLEM**INSUFFICIENT OPACITY**

- | | | | |
|-----------------------------|-------------------------|---|---|
| > too thin | > too flat | > surface contaminated | > doctor blade pulls ink out of image (open system) |
| > colour too transparent | > not screened | > dark substrate colour | |
| > ink transfer insufficient | > motive not inclined | > tension cracks in injection moulded materials | |
| | > wrong screening width | | |

POSSIBLE SOLUTIONS

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|--------------------------|-------------------------------|------------------------|---|--|
| ● adjust colour | ● use deeper cliché | ● use sharper pad | ● clean surface | ● use stronger doctor blade, screen motive and incline areas and lines |
| ● mix more opaque colour | ● screen motive | ● use correct hardness | ● apply double prints | |
| ● check cliché and pad | ● incline motive | ● insert new pad | ● use mild ink system with mild thinner | |
| | ● use coarser screening width | | | |

POSSIBLE SOURCE OF PROBLEM**> INK****> CLICHÉ****> PAD****> SUBSTRATE > OTHER**